

Work Order ID 71933

Wednesday, July 13, 2011 12:55:11 PM



Page 1

Item ID: D4274-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Aft Support

Start Date: 7/13/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *MF*

Date: 11-09-13

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4274

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

304 .125

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

W 11 07 18 (6)

W 11 07 18 (6)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan:

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 135B

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:



(46)

6/17/19 (6)

11/7/19

MF
11-07-19

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DART AEROSPACE LTD		Work Order: 71933
Description: Plate, Aft Support		Part Number: D4274-3
Inspection Dwg: D4274	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.131	✓		VERN	M.M.-01
Ø0.191	+0.005/-0.001	0.191	✓		VERN	M.M.-01
Ø0.250	+0.006/-0.001	0.250	✓		VERN	M.M.-01
Ø0.53	+0.008/-0.001	0.53	✓		VERN	M.M.-01
4.25	+/-0.030	4.257	✓		VERN	M.M.-01
1.02	+/-0.030	1.022	✓		VERN	CNC-02
3.83	+/-0.030	3.827	✓		HG	31006
0.310	+/-0.010	0.315	✓		VERN	M.M.-01
0.750	+/-0.010	0.749	✓		VERN	M.M.-01
7.05	+/-0.030	7.07	✓		HG	31006
0.92	+/-0.030	0.921	✓		VERN	M.M.-01
5.91	+/-0.030	5.91	✓		VERN	CNC-02 CNC-02
8.95	+/-0.030	8.96	✓		VERN	CNC-02
2.80	+/-0.030	2.798	✓		VERN	M.M.-01
1.05	+/-0.030	1.055	✓		VERN	M.M.-01
0.60	+/-0.030	0.607	✓		VERN	M.M.-01
1.20	+/-0.030	1.209	✓		VERN	M.M.-01
1.10	+/-0.030	1.089	✓		VERN	M.M.-01
0.75	+/-0.030	0.754	✓		VERN	M.M.-01
3.000	+/-0.010	3.000	✓		VERN	M.M.-01
1.500	+/-0.010	1.501	✓		VERN	M.M.-01
2.300	+/-0.010	2.298	✓		VERN	M.M.-01
1.367	+/-0.010	1.374	✓		VERN	M.M.-01
0.36	+/-0.030	0.365	✓		HG	31006
0.792	+/-0.010	0.790	✓		HG	31006
0.672	+/-0.010	0.670	✓		HG	31006
0.464	+/-0.010	0.465	✓		HG	31006
0.70	+/-0.030	0.703	✓		HG	31006
3.000	+/-0.010	3.005	✓		VERN	M.M.-01
0.750	+/-0.010	0.755	✓		VERN	M.M.-01
0.68	+/-0.030	0.707	✓		VERN	M.M.-01

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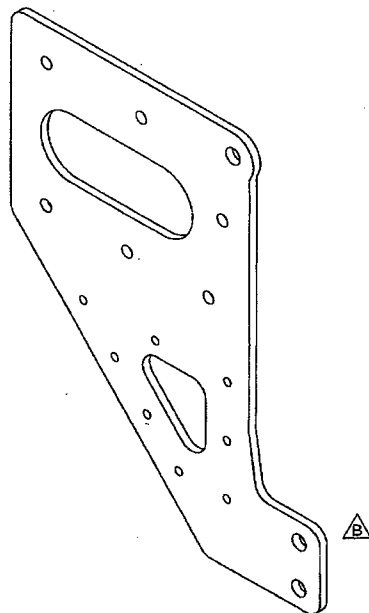
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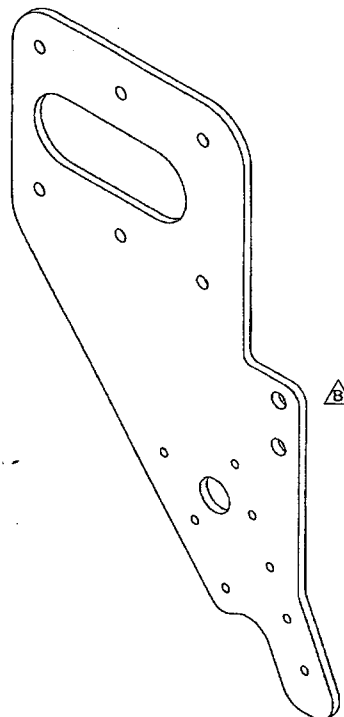
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D4274-1 PLATE, FWD SUPPORT



D4274-3 PLATE, AFT SUPPORT

#71933

RELEASED
2010-08-05

B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS	SC	10.12.02
A	NEW ISSUE	SC	10.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLATES, BASKET SUPPORT	NTS
DATE	10.12.02	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

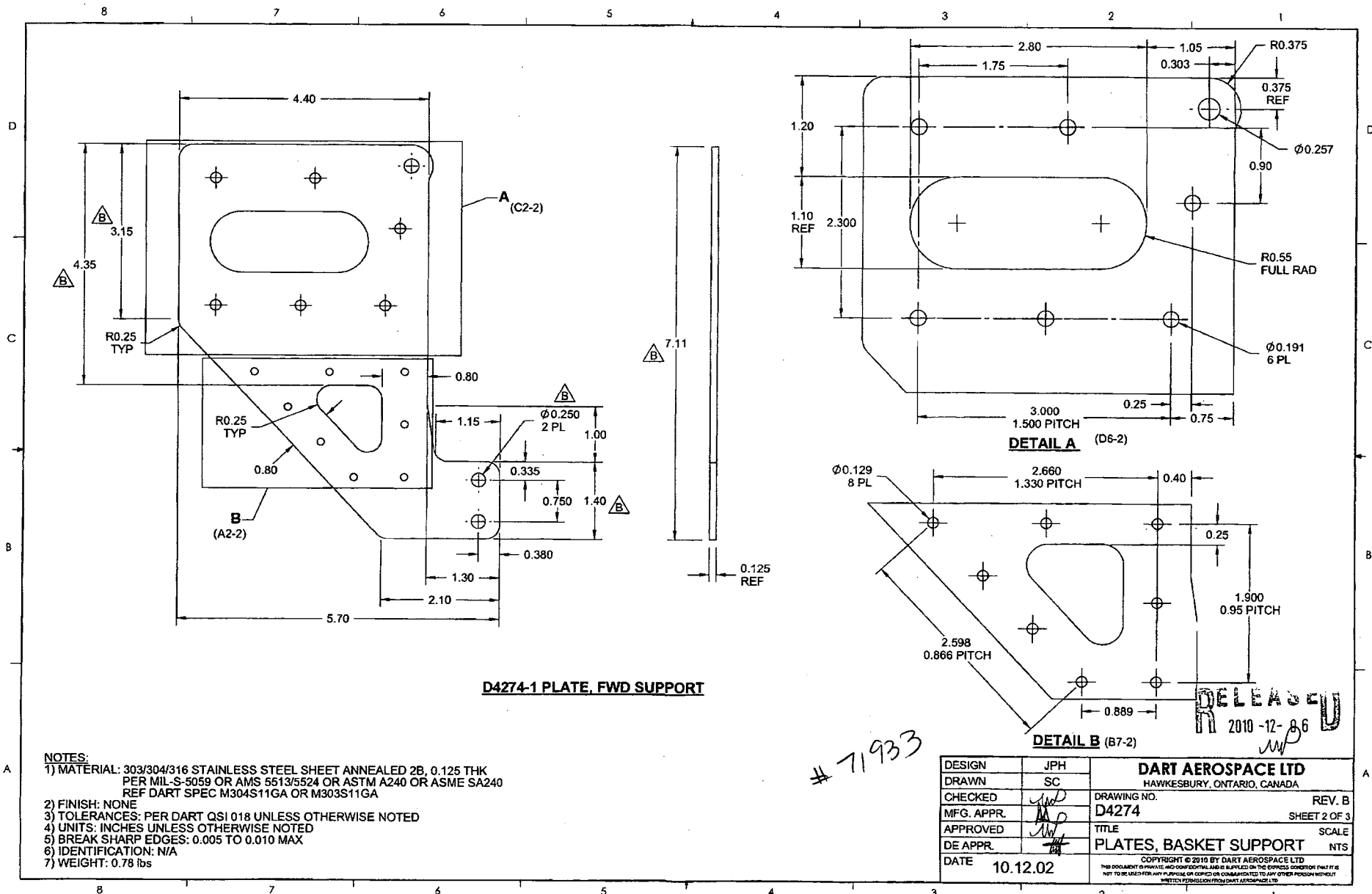
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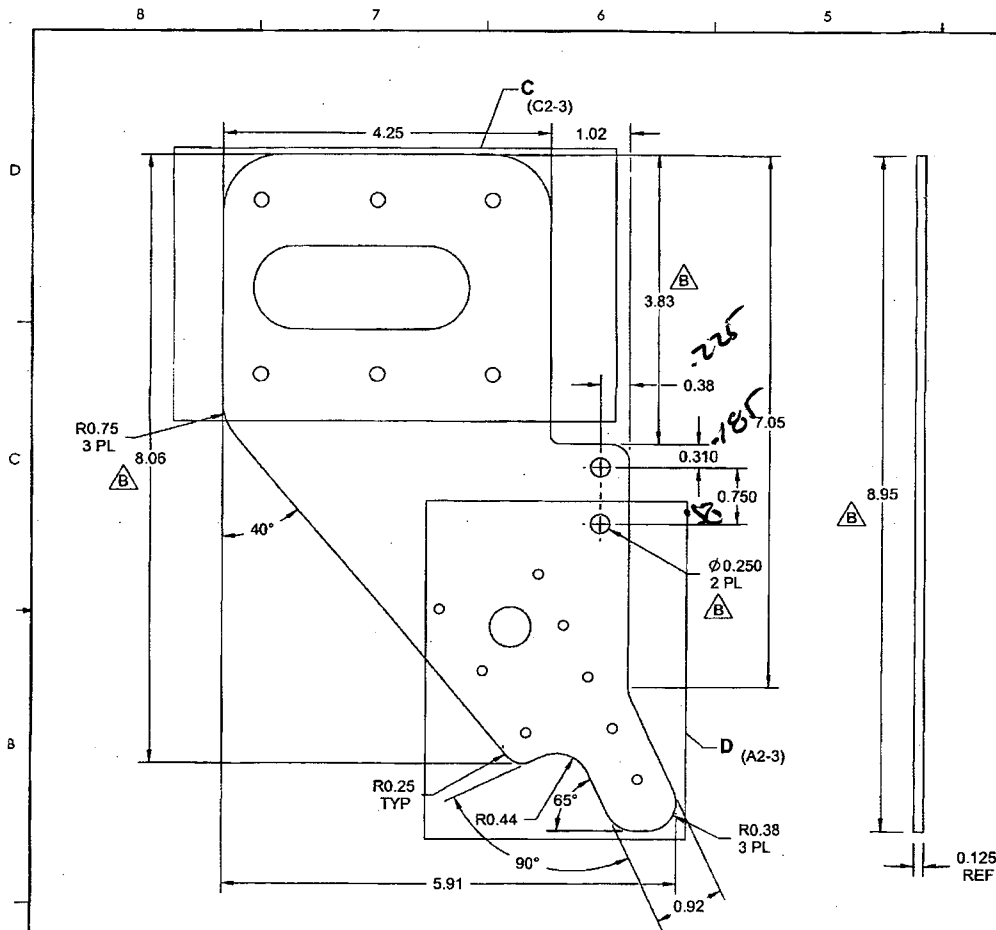
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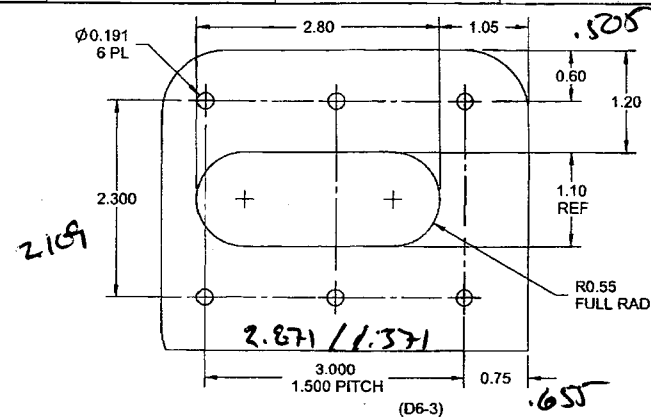
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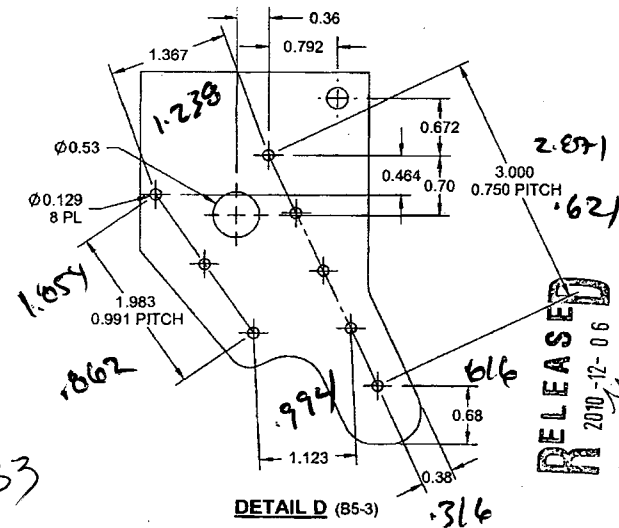
D4274-3 PLATE, AFT SUPPORT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.97 lbs



DETAIL C



DETAIL D (B5-3)

71933

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SG	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	MD	D4274	SHEET 3 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	PLATES, BASKET SUPPORT	NTS
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RELEASED
2010-12-06
JMD

1574

125
096
065

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